

Order ID 111362

11-13-14 3:06:58 PM

\*111362\*

Page 1

Item ID: D350-591-121 Accept

Revision ID:

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00

Required Date: 1/27/14 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: MLJ Date: 14-01-13

QC: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Cust Item ID:

Customer:

Run Start \*NR1\*

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2351-041	Rev E								

100

\*100\*

DC

Document Control

DOCUMENT CONTROL

Memo

Photocopy bluefile and type labels as per PPP D350-591-121 CHG005

0.00

DAS

06

9-07 MAY 13 2014

0.00

Sx

110

\*110\*

Large Fab

Large Fab

Large Fab

Memo

1-Cut D2244-116 extrusion to 55.32" long as per Dwg D2351 using cutting table setup DT8185-G

2-Drill extrusion per Dwg D2351 using Jig DT8230 for rivets.

3-Deburr

0.00

0.00

5

6

14-01-13

DAS  
28  
9-89



Work Order ID 111362

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\*111362\*

Page 2

Item ID: D350-591-121

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00 \*4\*

Cust Item ID:

Required Date: 1/27/14 Req'd Qty: 4.00 \*4\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
<b>*120*</b>	BENDING MACHINE - SKIDTUBES								
CNC Bend 1	Memo	0.00							
CNC Delta 100 Bender	Bend as per Dwg D2351-041 using CNC Bender 1 and Folio FT011. Use Bend Program D2351-041.								
130		0.00							
<b>*130*</b>	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									
140		0.00							
<b>*140*</b>	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Bevel Fwd and Aft end for welding								
	2-Weld Aft End Bracket per OSI004 & Dwg D2351 using Welding Jig DT8033								
	A/RAluminum Rod <i>12512</i>								
	3-Do not Grind Flush <i>128505</i>								
	<i>Wheel Marks from bender</i>								

*DP/da 14-1-15*

*5 14-04-29*

*5 14-01-31/14 14-04-29*

**Work Order ID 111362**

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**\*111362\***

Page 3

Item ID: D350-591-121

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/27/14 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

150 QC9- Inspect visual per QSI004- Fusion Welds 0.00

**\*150\***

QC Memo 0.00

Quality Control

(5) 14-04-29 DAS  
9  
9-89

160 QC5- Inspect part completeness to step on W/O 0.00

**\*160\***

QC Memo 0.00

Quality Control

(5) 14-04-29 DAS  
9  
9-89

170 Chemical Conversion Coat per QSI005 4.1 0.00

**\*170\***

HandFinish Memo 0.00

Hand Finishing

5 / DC  
14-04-30  
7/6

January-13-14 3:06:58 PM

Page 4

**Reference:**

Stop \*NR2\*

**Insp.  
Stamp**

0.00

## Memo

## Quality Control

0.00

## Large Fab

0.00

Large Fab

## Large Fab

## Memo

1-Rivet Leg Assembly as per Dwg D2351<sup>3</sup>

2-Weld Fwd End Plate per QSI 004 & Dwg D2351

A/R Aluminum Rod 125127

3-Grind end cap flush per dwg D2351

0.00

QC10- Inspect visual per QSI004- ground welds

0.00

QC

## Memo

## Quality Control

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Page 5

Item ID: D350-591-121

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/27/14 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
<b>*230*</b>						⑤	14-05-09		
QC	Memo	0.00							
Quality Control									
240	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*240*</b>						5	7-14-5-10		
HandFinish	Memo	0.00							
Hand Finishing									
250	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
<b>*250*</b>						5	14-5-12		DAS 34 9-89
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:30 OVEN TEMPERATURE: 320 FINISH TIME: 9:50								

10 20 4

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**\*111362\***

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Item ID: D350-591-121

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00 **\*4\***

Cust Item ID:

Required Date: 1/27/14 Req'd Qty: 4.00 **\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260	Wing Walk as per dwg QSI005 4.4 Batch <u>1128909</u>								
<b>*260*</b>									
HandFinish	Memo	0.00				5 htl	d	ll	veloster
Hand Finishing									
270	QC3- Inspect Part Finish								
<b>*270*</b>									
QC	Memo	0.00				5			
Quality Control									
280	Pick Kit								
<b>*280*</b>									
Packaging	Memo	0.00				5			
Packaging									

DAS  
28  
9-89

2008-14-05-13



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**\*111362\***

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Item ID: D350-591-121

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Stop

**\*NS2\***

Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/27/14 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_

Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

290

QC4- 100% Inspect kits for completeness

0.00

MAY 13 2014

**\*290\***

QC

Memo

0.00

DAS  
06  
9-89

Quality Control

300

Packaging

0.00

**\*300\***

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-591-121

Location: 0601  
PPP Rev: \_\_\_\_\_DAS  
06  
9-89DAS  
28  
9-89

310

QC21- Final Inspection - Work Order Release

0.00

**\*310\***

QC

Memo

0.00

Quality Control

MLS 1405-13

YMF  
14-5-13

# Picklist Print

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Page 1

Work Order ID: 111362

**\*111362\***

Parent Item: D350-591-121

**\*D350-591-121\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:E02.10.21Re-format; Incorporated D2351-041 IPPKJ/RF  
IPP rev. F 06.02.23 added grinding EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2244-116      Manufactured      No

110

Each

59.0000

0.5

3

**\*D2244-116\***

STEP EXTRUSION

**\*\***

*14.01.13*

Location

Loc Qty

Loc Code

WA003

*B104940*

58.9999632

*2.5*

60307

9

80803

24

89954

26

D2850-1      Manufactured      No

140

Each

7.0000

1

4

**\*D2850-1\***

End Bracket

**\*\***

*14.04.28*

Location

Loc Qty

Loc Code

WA003

*B111633*

7

*3*

107449

7

*2*

D2582      Manufactured      No

190

Each

12.0000

1

4

**\*D2582\***

Hi-Skid Step Leg Ass'Y

**\*\***

*14.05.07*

Location

Loc Qty

Loc Code

WA003

*B111490*

12

*1*

106091

12

*4*

*B112353*

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Page 2

Work Order ID: 111362

**\*111362\***

Parent Item: D350-591-121

**\*D350-591-121\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

MS20600-AD4W3

Purchased

No

190

Each

941.0000

16

64

**\*MS20600-AD4W3\***

Cherry Rivets

**\*\***

*14-05-07*

Location

Loc Qty

Loc Code

ST311

572

122151

100

m127476

472

WA003

369

107939

369

D2673-34

Manufactured

No

210

Each

43.0000

1

4

**\*D2673-34\***

End Plate

**\*\***

*14-04-28*

Location

Loc Qty

Loc Code

WA003

43

103377

9

109579

34

AN4-16A

Purchased

No

290

Each

263.0000

**\*\***

*8-10*

*128324*

DAS  
33  
9-89

*14-05-13*

Location

Loc Qty

Loc Code

FG

5

121541

5

ST357

8

M126073

8

ST515

250

M127432

100

M127817

150

DAS  
28  
9-89

DAS  
06  
9-89

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Shop Packet Print

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Work Order ID: 111362

**\*111362\***

Parent Item: D350-591-121

**\*D350-591-121\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

D2856-400

Manufactured No

290

f

213.0000

0.5

2 4.00

DAS

33

9-89

DAS

28

9-89

**\*D2856-400\***

Abrasion Strip 4" Wide (Per Foot)

DAS

06

9-89

Location

Loc Qty

Loc Code

ST403

213

109578

213

cut (1) at 7.20"

NAS1149D0463J

Purchased No

290

Each

7,949.000

6

2430

DAS

33

9-89

DAS

28

9-89

**\*NAS1149D0463J\***

WASHER

DAS

06

9-89

Location

Loc Qty

Loc Code

ST294

3549

M127693

3549

ST510a

4400

M127813

1400

M127904

3000

D2230-1

Manufactured No

290

Each

61.0000

1

45

DAS

33

9-89

14-05-13

**\*D2230-1\***

Mounting Lug

DAS

06

9-89

Location

Loc Qty

Loc Code

FG

4

84136

4

ST469

57

101834

6

102280

14

108669

37

DAS

28

9-89

January-13-14 3:07:06 PM

Shop Packet Print

Page 3

# Picklist Print

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Work Order ID: 111362

**\*111362\***

Parent Item: D350-591-121

**\*D350-591-121\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

AN3-37A

Purchased

No

290

Each

176.0000

2

810

DAS  
33

DAS  
28  
9-89

**\*AN3-37A\***

Bolt

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

10

119086

10

ST353

166

123355

166

123355

MS21042L3

Purchased

No

290

Each

5,824.000

2

810

DAS  
33

DAS  
28  
9-89

**\*MS21042L3\***

Nut

DAS  
06  
9-89

Location

Loc Qty

Loc Code

ST506

962

123900

962

ST509

4862

M127304

1000

M127410

3000

M127831

862

128401

AN4-13A

Purchased

No

290

Each

1,576.000

3

1215

DAS  
33

9-89 14-05-13

**\*AN4-13A\***

Bolt

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

17

m125709

17

ST356

58

m126193

58

ST515

1481

m126193

431

m127432

50

m127817

1000

DAS  
28  
9-89

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Work Order ID: 111362

\*111362\*

Parent Item: D350-591-121

\*D350-591-121\*

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

MS21042L4

Purchased

No

290

Each

5,061.000

3  
\*\*

12 15

128300

DAS  
33  
9-89

DAS  
28  
9-89

\*MS21042L4\*

Locknut

Location

Loc Qty

Loc Code

GA

80

m126333

80

ST509

4000

m127255

2000

m127813

2000

ST518

981

m127376

981

D2230-3

Manufactured

No

290

Each

409.0000

1  
\*\*

4 35

114151

DAS  
33  
9-89

14-05-13

\*D2230-3\*

Mounting Lug

Location

Loc Qty

Loc Code

FG

3

89045

3

ST469

406

105940

168

108668

238

DAS  
28  
9-89

DAS  
06  
7-89

January-13-14 3:07:10 PM

Shop Packet Print

Page 5

# Picklist Print

January-13-14 3:07:10 PM

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Work Order ID: 111362

**\*111362\***

Parent Item: D350-591-121

**\*D350-591-121\***

Parent Item Name: Heli-Access-Step™ LH

Start Date: 1/13/14

Required Date: 1/27/14

Start Qty: 4.00

Required Qty: 4.00

D2732-030

Manufactured No

290

Each

291.0000

**\*\* 2**

8/10

DAS

33

9-89

DAS  
28  
9-89

**\*D2732-030\***

Rubber Cushion (Replaces P/N G13013-4)

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

FG	131	
101857	18	
83560	17	
94725	75	
98629	21	
ST127	30	
104906	30	
ST409	130	
102705	2	
105477	20	
110612	100	
64283	8	

cut (2) at 3.00"

NAS1149D0363J

Purchased

No

290

Each

3,501.000

**\*\* 4**

16 20

DAS

33

9-89

14-05-13

**\*NAS1149D0363J\***

Washer

DAS  
06  
9-89

## Location

## Loc Qty

## Loc Code

GA	110	
124392	110	
ST510a	3391	
m126319	2191	
m127813	1200	

DAS  
28  
9-89

January-13-14 3:07:11 PM

Shop Packet Print

Page 6

**DART**

DESIGN KE	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2351	REV. E SHEET 1 OF 2
DATE 05.11.14		TITLE HIGH FLOAT STEP ASSEMBLY	SCALE NTS
A	95.02.15	NEW ISSUE	
B	97.05.22	END CAPS CHANGED	
C	97.07.23	ADDED BUSHING AND FACING INFO	
D	98.12.17	CHANGED TO BEND, D2850 REPLACES D2357 & D2358, INCORP. DEO 9084	
E	05.11.14	UPDATE FINISHING NOTE	

11/362 MCT 14-01-13

**D2351 HIGH FLOAT STEP ASSEMBLY PARTS LIST**

Part No.	Description	QTY -041	QTY -042
D2351-041	High Float Step Assembly (LH)	X	
D2351-042	High Float Step Assembly (RH)		X
D2244-55.4	STEP EXTRUSION*	1	1
D2582	STEP LEG ASSEMBLY	1	1
D2673-34	STEP END PLATE	1	1
D2850-1	END BRACKET	1	
D2850-2	END BRACKET		1
MS20600AD4W3	RIVETS	16	16

\*cut per drawing

RELEASED  
05.11.28 [Signature]

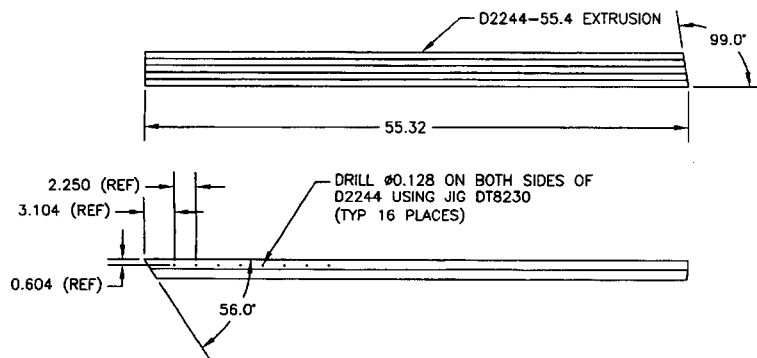
ECN 1105  
UNDER REVIEW  
07.11.29 [Signature]  
PER NCR# 263

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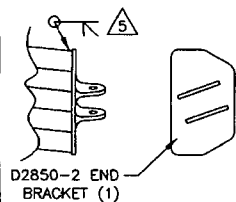
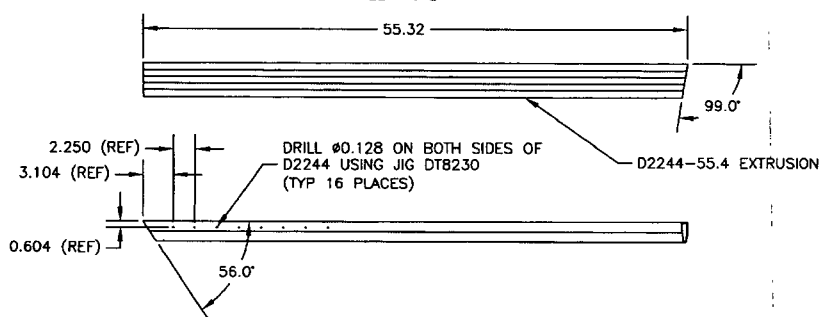
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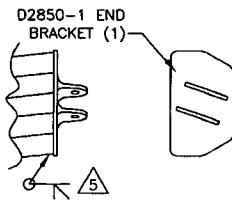
D2351-2 CUTTING/DRILLING DETAIL  
RIGHT STEP



D2351-1 CUTTING/DRILLING DETAIL  
LEFT STEP



DETAIL A  
SCALE: 1:4



DETAIL B  
SCALE: 1:4

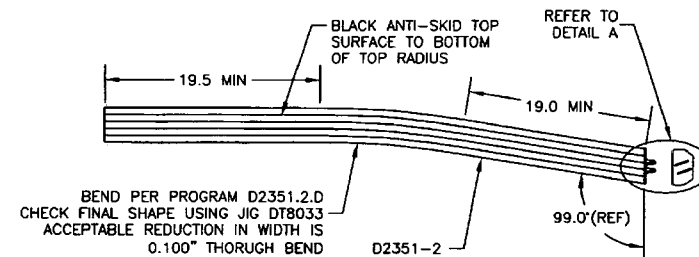
D2582 STEP LEG ASSEMBLY (1)



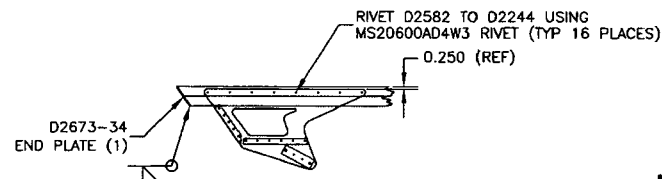
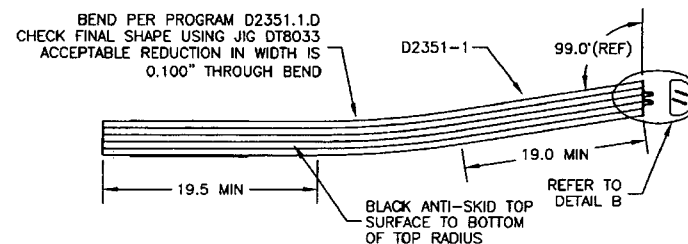
GENERAL NOTES

- 1) WELD PER DART QSI 004
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
  - 3) ALL DIMENSIONS ARE IN INCHES
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- △ CHAMFER D2244 EXTRUSION 0.075"x45° BEFORE WELDING D2850-1 OR D2850-2 IN PLACE. DO NOT GRIND FLUSH.

D2351-042 BENDING/ASSEMBLY DETAIL  
RIGHT STEP



D2351-041 BENDING/ASSEMBLY DETAIL  
LEFT STEP



RELEASED  
05.11.14

UNDER REVIEW

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DESIGN KE	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2351	REV. E SHEET 2 OF 2
DATE 05.11.14	TITLE HIGH FLOAT STEP ASSEMBLY	SCALE 1:12	



MAY 13 2014

DART AEROSPACE LTD  
REFERENCE ONLYD350-591  
Page 22 of 23

## 5. PARTS LIST

DAS  
06

Qty -111A	Qty -113	Qty -115	Qty -117A	Qty -119	Qty -133	Part Number	Description
X						D350-591-111A	<b>Heli-Access-Step</b> ™, Long Step – High Skid
	X					D350-591-113	<b>Heli-Access-Step</b> ™, Short Step – High Skid
		X				D350-591-115	<b>Heli-Access-Step</b> ™, Short Step – Low Skid
			X			D350-591-117A	<b>Heli-Access-Step</b> ™, Pre-Flight Step
				X		D350-591-119	<b>Heli-Access-Step</b> ™, Long Step – Low Skid
					X	D350-591-133	<b>Heli-Access-Step</b> ™, Aft Maintenance Step
	1					D2310	STEP ASSEMBLY (HIGH-SHORT)
1						D2311	STEP ASSEMBLY (HIGH-LONG)
		1				D2354	STEP ASSEMBLY (LOW-SHORT)
				1		D2355	STEP ASSEMBLY (LOW-LONG)
					1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
4	2	2	2	2		D2171	CLAMP
4	2	2	2	2		D2182B035	CUSHION
					4	D2230-1	MOUNTING LUG
					4	D2230-3	MOUNTING LUG
8	4	4	4	4		D2274	RADIUS BLOCK
			1			D2362-041	SUPPORT BRACKET
2	1			1		D2362-3	SUPPORT BRACKET
		1				D2362-5	SUPPORT BRACKET
2	1	1	1	1	2	D2856-400-720	ABRASION STRIP
					1	D2945	MOUNTING PLATE
2	2	2		2		AN3-37A	BOLT
					2	AN4-7A	BOLT
					4	AN4-11A	BOLT
					8	AN4-14A	BOLT
		4				AN4-16A	BOLT
8	4			4		AN4-20A	BOLT
1	1	1	4	1		AN4-22A	BOLT
4	4	4		4		AN960JD10	WASHER
10	6	2	4	6	14	AN960JD416	WASHER
		4				AN960JD416L	WASHER
2	2	2		2		MS21042L3	NUT
9	5	5	4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<b>Heli-Access-Step</b> ™, Short Step – High Skid, LH
	X			D350-591-122	<b>Heli-Access-Step</b> ™, Short Step – High Skid, RH
		X		D350-591-123	<b>Heli-Access-Step</b> ™, Short Step – Low Skid, LH
			X	D350-591-124	<b>Heli-Access-Step</b> ™, Short Step – Low Skid, RH
				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
1	1	1	1	D2856-400-720	ABRASION STRIP
2	2	2	2	AN3-37A	BOLT
3	3	3	3	AN4-13A	BOLT
4	4	4	4	AN960JD10	WASHER
6	6	6	6	AN960JD416	WASHER
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT

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Revision: G  
Date: 08.10.06

# DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER  
AND  
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER  
REF CANADIAN STC: SH92-6  
REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

## ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
<del>2</del>	2	2	2	8	D2732-030	CUSHION
<del>2</del>	2	2	2	8	AN4-16A	BOLT






The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA  
DEPARTMENT OF TRANSPORT  
AIRCRAFT CERTIFICATION  
BRANCH  
DAO # 01-O-01

APPROVED  
BY:   
D. SHEPHERD (DE # 02)

DATE: 09.06.24  
CERT. NO.: SH92-6  
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
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